

Date: Tuesday, 05/12/2006 1:58:27 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : TOW RING
<b>Job Number</b> : 29836	
<b>Estimate Number</b> : 10396	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D2968041
<b>This Issue</b> : 05/12/2006 <b>S.O. No.</b> : <i>ALA</i>	<b>Drawing Number</b> : D2968
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B1
<b>Previous Run</b> : 29791	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 23/12/2006 <b>Qty:</b> 30 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	
<b>Comment</b> : Est:C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	<del>29836A</del>	STEM
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Comment: Sub-Component STEM

D2968-1 B *28697**06/12/06**32*

2.0	<del>29836B</del>	RING
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Comment: Sub-Component RING

D2968-5 B *28267 h (15)**B28865 h (8)**B29953 h (9)**06/12/06**32*

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld D2968-1 &amp; D2968-5 as per Dwg D2968 &amp; QSI 004 using 4130 welding rod Identify as D2968-041

Batch: *M15684**06/12/06**32*

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

*PD 06-12-07**4:47*

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*PD 06-12-07*

6.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *21667*

Description: D2968-041 to heat treat to ultimate tensile strength

125ksi as per Dwg D2968

*C206112108*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 05/12/2006 1:58:28 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 29836

Part Number: D2968041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Conformity sheet required

Issue P/O: 2668

C266112108

Cad Plate per QQ-P-416F Class I Type II

Conformity sheet required

(32)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

7/01/08

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT CAD PLATE

07-01-10

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

\*\*\*DO NOT POWDER COAT THREADS\*\*\*

m.A/m

07/01/11

(32x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

m 07/01/11

(32)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57113

7/01/12

(32)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/12

(32)

Job Completion



u 07-01-12

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**MANCO**  
**DOMPLEX**

8895 Crescent 3  
Anjou (Québec) H1J 1B6  
Tél.: 514-355-7867  
Fax: 514-355-8750

**CERTIFICAT DE CONFORMITÉ**  
**CERTIFICATE OF COMPLIANCE**

# 13046

DART Aerospace LTD  
Client / Customer

D2968-041 B29836  
# de la pièce / part #

102668  
Votre # de commande / Your purchase order #

101843  
Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector <u>Renault</u>	Date, équipe / Date, shift <u>29 Dec 2006</u>
Placage / Plating <u>QRP416 F CLASS 1 - Type II -</u>	
Quantité totale / Total quantity <u>32</u>	Quantité inspectée / Inspected quantity <u>32</u>
Adhésion / Adhesion <u>Bonne</u>	
Épaisseur / Thickness L.C.D.	H.C.D. Moy. / aver. <u>0.0005</u>
Coulisses, taches / Leach, spots <u>non</u>	Rugosité / Roughness <u>non</u>
Quantité approuvée / Approved quantity <u>32</u>	Quantité rejetée / Rejected quantity <u>                    </u>

Commentaires / Comments

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de /  
Signed on behalf of

**MANCO**  
**DOMPLEX**


**VAC AERO**  
INTERNATIONAL INC.

# RELEASE NOTE

GST No.: R105468102

OAK 82322-1



HEAD OFFICE  
1371 SPERRS ROAD, OAKVILLE, ONTARIO  
CANADA L6L 2X5  
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B  
OAKVILLE, ONTARIO  
CANADA L6J 6J4  
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION  
7450 RUE VERTE STREET, ST. LAURENT, QUEBEC  
CANADA H4S 1C5  
TEL: (514) 334-4240 FAX: (514) 334-6269

12/29/2006

MM / DD / YYYY

PAGE: 1

BILL TO: 1DAR01  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

SHIP TO: MANCO DAMPLEX  
4660 HICKMORE  
ST. LAURENT, PQ

K6A 1K7

H4T 1K2

DATE SHIPPED	SHIP VIA	F.O.B.
12/29/2006		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
PO00002667		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D2968-041	TOW RING	EA	32	32	
Process Specifications: Procedure: 4047 HEAT TREATED TO 125 KSI MIN. 100% HARDNESS TESTED PER ASTM E-18, HRC 27-32.5 MATERIAL: 4130  B29836					
D2968-043	TOW RING	EA	30	30	
Process Specifications: Procedure: 4047 HEAT TREATED TO 125 KSI MIN. 100% HARDNESS TESTED PER ASTM E-18, HRC 27-32.5 MATERIAL: 4130  B29353  * AMENDMENT #1, JAN. 10, 2007					

**100% HARDNESS TESTED**

64 ps.

31/32 HRC



I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

*Diana Freeman*  
Authorized Q.C. Inspector


**HEAT  
TREATING**

VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT  
TURBINE COMPONENT OVERHAUL - PLASMA AND OTHER COATINGS

